

38

Date: Tuesday, 8/21/2007 2:09:36 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206L FWD X-TUBE
Job Number : 34138	
Estimate Number : 10553	
P.O. Number : N/A	Part Number : D206667103BL
This Issue : 8/21/2007 S.O. No. : N/A	Drawing Number : D206-667-143 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LANDING GEAR	Drawing Revision : N/A
Previous Run : 33157	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 9/20/2007 Qty: 1 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est Rev: F 05.09.01 Add holes for compatibility with Bell Skidtubes KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-103 CHG002

J-F. 07/10/22

2.0

D6002115

Crosstube material



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number

Description Batch

1 D6002-115

Crosstube

B25662

Check OD = 2.250"; ID = 1.750"

J-F. 07/09/23

3.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA087

2-Turn first side as per Folio FA087

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143.

J-F. 07/09/23

4.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

J-F. 07/09/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 8/21/2007 2:09:36 PM

User: Kim Johnston

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 34138

Part Number: D206667103BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA087

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143.

3-Remove sand and plugs

4-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-143

Inside of Cuff(Donot engrave on outside of tube)

J.F.

07/09/23

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

J.F. 07/09/23

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 07/09/23

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

JB 7-9-27

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

E 07/09/27

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SR 7-9-27

11.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-143 using CNC bender program 206L-fw and Folio FT017

EL 7-10-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 34138

Part Number: D206667103BL

Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

En 07/10/10

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill all (3) top holes.

2-Drill and Ream all holes in tube to finish size using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8541 & DT8542 as per Dwg D206-667-143

6-Drill Fwd rivet holes using drill Jig DT8787FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8787AFT as per Dwg D206-667-143.

8-C'sink holes as per Dwg D206-667-143. Allow rivet to sit below surface to compensate for paint.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143

E2/SR
7-10-10

JD 7-10-11

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JD 7-10-11

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

JA-10-12 @

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JA-10-12 @

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 34138

Part Number: D206667103BL

Job Number:



Seq. #:	Machine Or Operation:	Description :
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17.0	OUTSIDE SERV.10	OUTSIDE SERVICES -LG
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Comment: Sub-Contracting OUTSIDE SERVICES
Liquid Penetrant Inspection as per QSI 038Or
Issue P/O: 4812 LPI as per ASTM 1417
Level 2 Attach copy of NDT results to work order

CL 7/11/16 ①

18.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Inspect for transit damage
Ensure copy of NDT results attached to work order.

CL 7/10/16

19.0	QC6	DIMENSIONAL CHECK
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Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

CL 8/10/16

20.0	SPRAY PAINTING	SPRAY PAINTING
------	----------------	----------------



Comment: SPRAY PAINTING

- RT 07-10-16*
- 1-Prime inside and outside crosstube as per QSI 005 4.2
 - 2-Paint outside crosstube DELFLEET BLUE
 - 3-CLEAR WITH DELFLEET

ml 07 10 19 ①

ISSUE P.O TO ATELIER DEBOSSSELAGE

21.0	QC14	INSPECT SPRAY PAINT
------	------	---------------------



Comment: Inspect Spray Paint
Wrap in plastic bag to protect from scratches

RT 07-10-21

22.0	D2856400	Abrasion Strip
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Comment: Qty.: 1.2138 f(s)/Unit Total : 1.2138 f(s)

Pick:

Qty Part number Description Batch

2 D2856-400(Cut to 6.94") Abrasion Strip

34293

RT 07-10-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 34138

Part Number: D206667103BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

D2873043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043

Nut Plate

33422

KT

07-10-16

24.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045

Nut Plate

33692

KT

07-10-16

25.0

D28911

Support 2.25 dia



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2891-1

Support

34147

KT

07-10-21

26.0

MS20601AD4W8

RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W8 Rivet

105057

KT

07-10-16

27.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-20

Clamp

104423

KT

07-10-21

28.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8579. .Note: (2) Aft holes should be facing up.

KT 07-10-21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 8/21/2007 2:09:36 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 34138

Part Number: D206667103BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Install supports and clamps as per Dwg D4206-667-143. Torque clamps to 80-100 in lb

ST 07-10-21

3-Install nut plates as per Dwg D206-667-143. Touch-up rivet heads with Imron paint.

ST 07-10-16

29.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 07/10/22

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

31.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch:

M104427

M104679

SC

32.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch:

M104812

SB

33.0

AN57A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:Packing Kit

Qty Part number

10 AN5-7A

Description Batch

Bolt

M103426

SC

34.0

AN530A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:Packing Kit

Qty Part number

4 AN5-30A

Description Batch

Bolt

M103641

7/10/22 SC

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 21/10/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 34138

Part Number: D206667103BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

AN960JD516

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick: Packing Kit

Qty Part number Description Batch

18 AN960JD516 Washer 7104156

7/10/22 SP

36.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

7/10/22

37.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-103

Location: _____

PPP Rev: _____

B 7/10/22 SP

38.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

①
7/10/23

Job Completion



U 8/10/23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 34138
Description: Crosstube Assembly (206L High Fwd)	Part Number: D206-667-143
Inspection Dwg: D206-667-143 Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

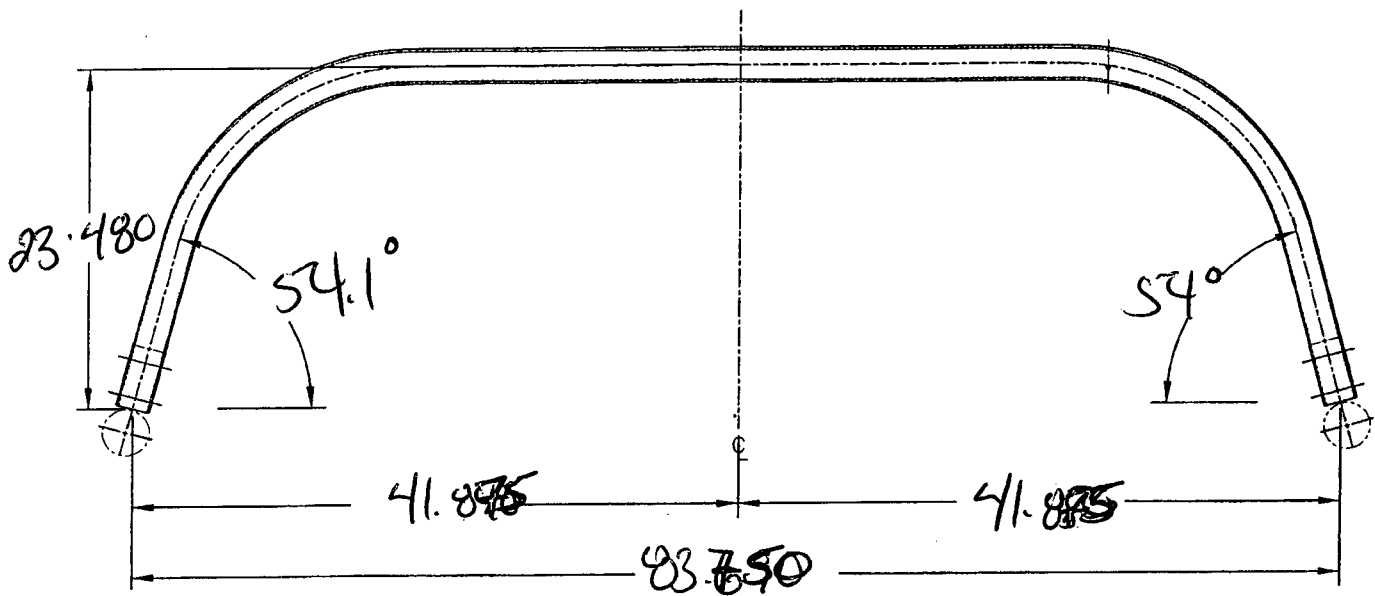
Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.242"	✓			
	1.982	+0.005/-0.000	1.985"	✓			
	2.019	+0.005/-0.000	2.023"	✓			
	2.058	+0.005/-0.000	2.062"	✓			
	2.097	+0.005/-0.000	2.101"	✓			
	2.136	+0.005/-0.000	2.139"	✓			
	2.176	+0.005/-0.000	2.180"	✓			
	2.201	+0.005/-0.000	2.204"	✓			
	0.125	+/-0.010	118"	✓			
	0.400 x 30°	+/-0.010	400 x 30°	✓			
	R0.063	+/-0.010	R0.063"	✓			
	R0.500	+/-0.010	R0.500"	✓			
	4.438	+/-0.030	4.443"	✓			
SIDE B	104.98	+/-0.020	104.990"	✓			
	2.240	+0.005/-0.000	2.244"	✓			
	1.982	+0.005/-0.000	1.986"	✓			
	2.019	+0.005/-0.000	2.023"	✓			
	2.058	+0.005/-0.000	2.062"	✓			
	2.097	+0.005/-0.000	2.101"	✓			
	2.136	+0.005/-0.000	2.139"	✓			
	2.176	+0.005/-0.000	2.180"	✓			
	2.201	+0.005/-0.000	2.205"	✓			
	0.125	+/-0.010	118"	✓			
	0.400 x 30°	+/-0.010	400 x 30°	✓			
	R0.063	+/-0.010	R0.063"	✓			
	R0.500	+/-0.010	R0.500"	✓			
	4.438	+/-0.030	4.442"	✓			

Measured by: J.F.	Audited by: J.P.	Prototype Approval:	N/A
Date: 07/09/23	Date: 07/09/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.05.06	New Issue (P/O D206-667-103)	KJ/RF	
B	06.03.09	Dwg Rev updated	KJ/JLM	

DART AEROSPACE LTD		Work Order:	34138
Description: Crosstube High Fwd (206L)		Part Number:	D206-667-103
Inspection Dwg: D206-667-143 Rev: B		Page 1 of 1	

Required Dimension	Min	Max
Height	23.46	23.58
1/2 Span	41.86	41.98
Angle	54	56
Total Span	83.72	83.96



Comments
note is about 0.030" out of 10" total
note is 0.10" under
the S.D. "B" is 0.000" under

QC15 Inspection	60
Date	07/10/10

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	<i>[Signature]</i>



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED HDS	APPROVED HDS	DRAWING NO. D206-667-143	REV. B SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206L HIGH FWD) NTS	
A	00.11.17	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED
05-07-26 H

UNDER REVIEW

05-08-10 PH

re-draw detail F
PH

070502

Qty	Part Number	Description
X	D206-667-143	CROSSTUBE ASSEMBLY (206L HIGH FWD)
1	D6002-115	CROSSTUBE
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2856-400-694	ABRASION STRIP
2	D2891-1	SUPPORT
14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
4	MS21920-20	CLAMP

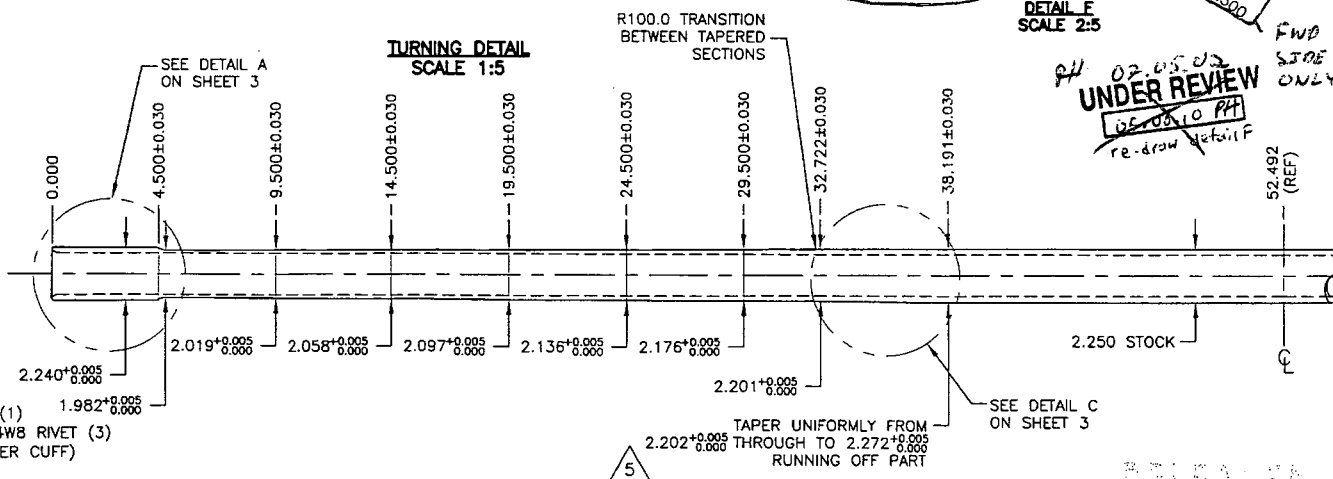
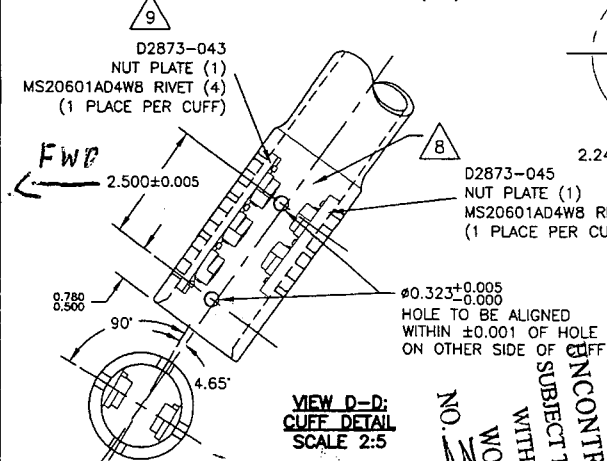
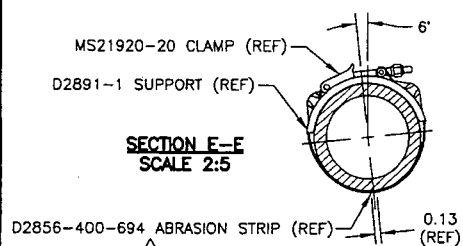
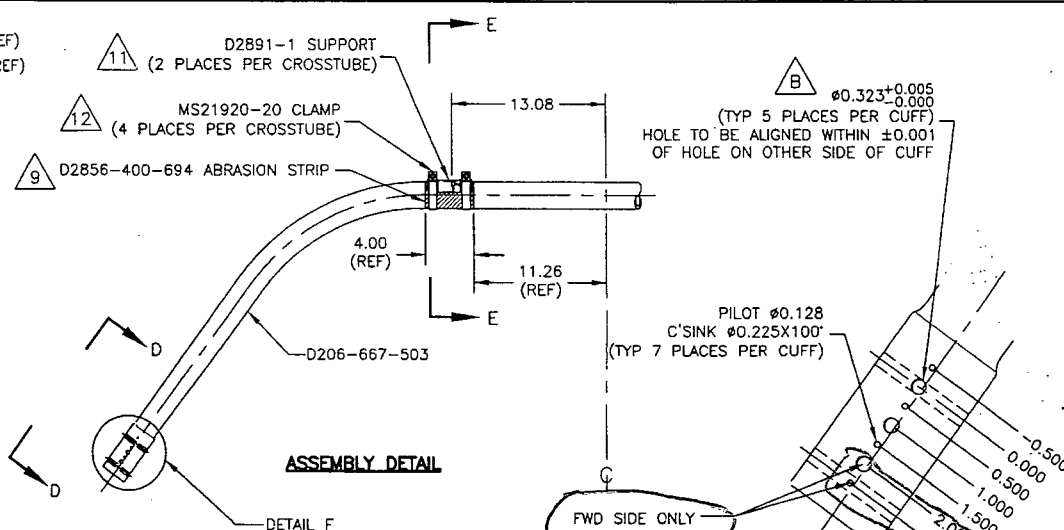
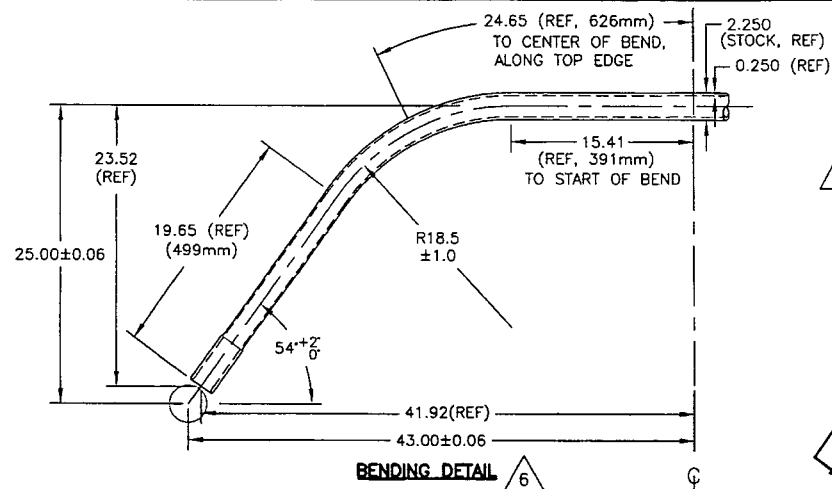
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6002-115
FINISHED LENGTH = 104.98±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-694 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2891-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX 241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34138

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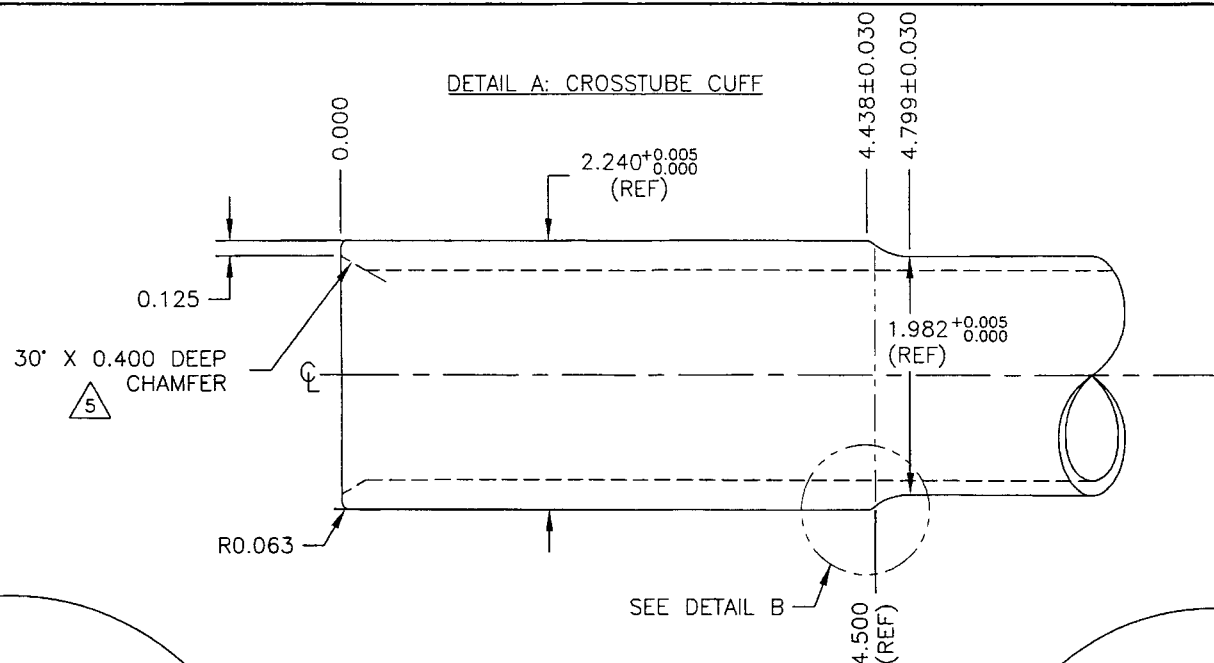
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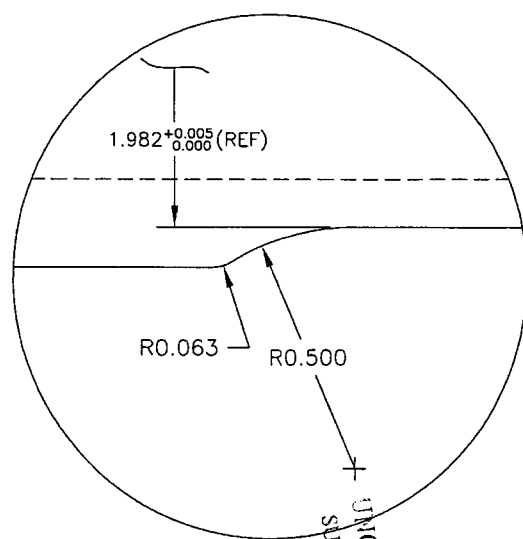
DESIGN PH		DRAWN BY PH		DART DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA	
CHECKED PH		APPROVED PH		DRAWING NO. D206-667-143	REV. B
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206L HIGH FWD)		SHEET 2 OF 3	
				SCALE 1:10	

SHOP COPY
RETURN TO
ENGINEERING
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WITHOUT NOTICE
WORK ORDER
NO. 34138

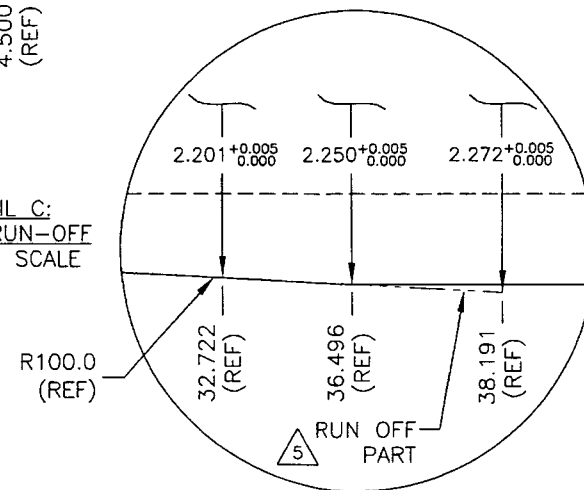
RELEASED
05-07-26



UNDER REVIEW
~~06.03.02 PH~~
~~re-draw detail F~~
 PH 07.05.02



DETAIL C:
 TAPER RUN-OFF
 NOT TO SCALE



NO. 34138
 WORK ORDER
 WITHOUT NOTICE
 SUBJECT TO AMENDMENT
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THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		PH	PH	DRAWING NO. D206-667-143	REV. B SHEET 3 OF 3
		CHECKED HDS	APPROVED HDS	TITLE CROSSTUBE ASS'Y (206L HIGH FWD)	SCALE 1:1
		DATE 05.07.26			



LIQUID PENETRANT TEST REPORT

P- 08662

PAGE 1 OF 1

CLIENT Dart Aerospace DATE October 18, 2007 TIME AM ☐ PM ☒
ATTENTION Bill Beckett ACUREN JOB NO. 188-07-01248
ADDRESS 1270 Aberdeen Street PO/WO No. _____
HAWKESBURY, Ontario K6A 1K7 WORK LOCATION as shown
PROJECT Cross Tube inspection ACCEPTANCE STD. E1417-99 REV./DATE 99
ITEM(S) EXAMINED Inspection of High Aft X Tube 412, 206L AFT X-Tube and 206L
FWD X-Tube as listed below

JOB DESCRIPTION _____ PROCEDURE NO. E1417 REV./DATE 99 TECHNIQUE NO. LT-XXXX-XXX REV./DATE _____
PART NO. D412664203, D206667203, D206667103 MATERIAL 7075 Aluminum THICKNESS < 1/2"
SCOPE 100% examination using Type I, Method A, Level 2 Penetrant examination
per Standard ASTM E1417-99

TEST DETAILS

METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIER
FAMILY BRAND Magnaflux Batch # 07E046 BLACK LIGHT S/N 10645 ☒ OUTPUT > 1000 μ W/cm² ☒ AMBIENT < 2 fc
PENETRANT Z167 MINIMUM DWELL TIME 10 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFAC
PENETRANT REMOVER Water MINIMUM DRY TIME >10 MIN. OTHER _____
DEVELOPER NA MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N _____ CAL DUE DATE _____
DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY Black light Calibration Due March 4, 2008

TEST SURFACE

SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☐ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE METAL
SURFACE TEMPERATURE ☐ < -4°C/20°F ☐ -4°C/20°F TO 10°C/50°F ☒ 10°C/50°F TO 52°C/125°F ☐ > 52°C/125°F

RESULTS-

☐ METRIC ☐ IMPERIAL

ITEM	COMMENTS	ACCEPT	REJECT
4 pieces P.N. D206667103			
Jb #'s, 34138, 34137, 33156, 34140			
1 piece P.N. D412664203 Jb # 33538			
1 piece P.N. D206667203 Jb # 34144			
All 6 pieces Acceptable			

Scope of Services

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SIGNATURES

CLIENT REPRESENTATIVE Benson Murrell DTR # 188-07-01248
TECHNICIAN (SIGNATURE): Mark Westover SIGNATURE _____
NAME (PRINT): Mark Westover REPORT REVIEWED BY: _____
1ST TECHNICIAN 2ND TECHNICIAN
CGSB LEVEL 2 SNT LEVEL 2 CGSB LEVEL _____ SNT LEVEL _____
CGSB REG. NO. 5323 CGSB REG. NO. _____

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Date: Tuesday, 8/21/2007 2:09:36 PM
 User: Kim Johnston

Process Sheet

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Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206L FWD X-TUBE
Job Number	: 34138		
Estimate Number	: 10553		
P.O. Number	:	Part Number	: D206667103BL
This Issue	: 8/21/2007 S.O. No. :	Drawing Number	: D206-667-143 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LANDING GEAR	Drawing Revision	:
Previous Run	: 33157	Material	:
Written By	:	Due Date	: 9/20/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>07.08.21</u>		
Comment	: Est Rev: F 05.09.01 Add holes for compatibility with Bell Skid tubes KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-103 CHG002

07.09.05

2.0	D6002115	Crosstube material
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6002-115 Crosstube

Check OD = 2.250"; ID = 1.750"

3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA087

2-Turn first side as per Folio FA087

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143.

REFERENCE ONLY

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET